










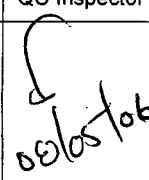


Date: Friday, 02/05/2008 2:55:43 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 39017	
Estimate Number : 13093	
P.O. Number :	Part Number : D3492053
This Issue : 02/05/2008 S.O. No. :	Drawing Number : D3492 REV C
Prst Rev. : NC	Project Number : N/A
First Issue : 1 / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 38430	Material :
Written By :	Due Date : 20/05/2008 Qty: 30 Um: Each
Checked & Approved By : <u>JLD 08.5.02</u>	
Comment : Est Rev:A New Issue 06-06-20 JLM Est Rev:B as per Rev C 07-12-06 DD verified by:EC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
1.0	M6061T6R0750
	6061-T6 Round Bar .750"
	 
Comment: Qty.: 0.0481 f(s)/Unit Total: 1.4427 f(s) 6061-T6 Round Bar .750" (M6061T6R0750) Batch: <u>103857</u> <u>7/2/mmE 08/05/06</u>	
2.0	HARDINGE
	HARDINGE CNC LATHE SMALL
	 
Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA715 & Dwg D3492 Dwg Rev: <u>C</u> Folio Rev: <u>AA</u> <u>7/2/mmE 08/05/06</u> <u>PA 08.05.06</u>	
3.0	QC2
	INSPECT PARTS AS THEY COME OFF MACHINE
	 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>7/2/mmE 08/05/06</u> ENGINEERING APPROVAL <u>PTO</u> SEE P.HUM AFTER 1 ST PART NEW DIM <u>PS</u>	
4.0	QC8
	SECOND CHECK
	 
Comment: SECOND CHECK <u>J.F. 08/05/18</u> <u>(30)</u>	
5.0	SMALL FAB 1
	SMALL & MEDIUM FAB RESOURCE 1
	 
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr <u>n/A 7/2/mmE 08.05.06</u>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
01.05.06 08.05.06	2 3	DIM ϕB NOW $\phi 0.510$ for better fit into skid tube spacer DWG WILL BE UPDATED	AK	08.05.06	ALL	AK 08.05.06	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 02/05/2008 2:55:43 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 39017

Part Number: D3492053

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(30)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-05-26

7.0

POWDER COATING

POWDER COATING



M107925



(30K)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:15
320 OF
11:45

M-L 08/05/26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-26

(30K)

9.0

NAS1611012

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-012 O-RING

(8X) => M106043
(22X) => M108038

08-05-26

(30)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube
A/R 55-O'Ring Lube Batch: M101223

08-05-26

(30)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/26 (X30)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FP-1

08-05-26

(X30)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 02/05/2008 2:55:43 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 39017

Part Number: D3492053

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

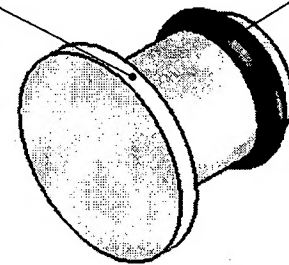
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

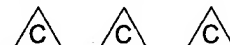
D3492-XX PLUG
(SEE TABLE)

NAS1611 PLUG
(SEE TABLE)



D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

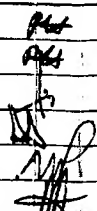


NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

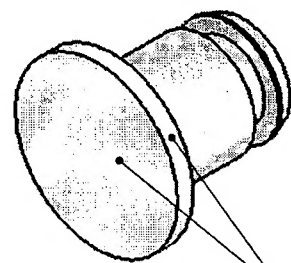
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39017

UNDER REVIEW
01.04.01 RGA
DIM 08 IN D3492-13
REST OK (MAKE SMALLER)
06.05.06

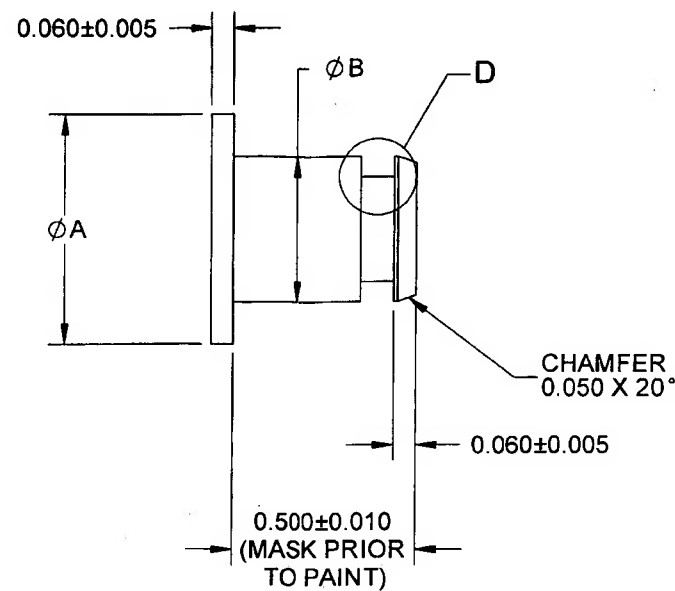
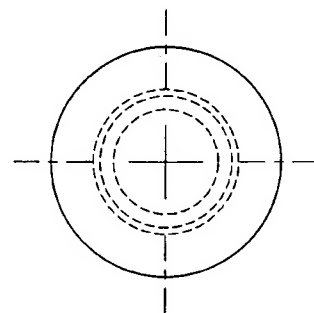
RELEASED
07.10.05

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05	DRAWING NO. D3492 REV. C SHEET 1 OF 2	
		TITLE PLUG SCALE 2:1	
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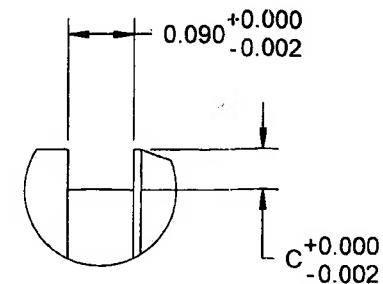
MS23775
0.070



POWDER COAT THESE
FACES ONLY PER NOTE 2



D3492-XX PLUG



DETAIL D

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

0.510 +0.000/-0.002
P4 06.05.05

NOTES:

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
39007

UNDER REVIEW
01.04.11 P4
DIM ØB ON D3492-13
REST OK (MAKE SMALLER)
P4 06.05.06

RELEASED
07.11.16

DESIGN	P4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	P4		
CHECKED	P4	DRAWING NO.	REV. C
MFG. APPR.	P4	D3492	SHEET 2 OF 2
APPROVED	P4	TITLE	SCALE
DE APPR.	P4	PLUG	4:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

